

Date: Tuesday, 4/4/2006 1:26:43 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LITTER TIE DOWN ASS'Y
Job Number	: 26488		
Estimate Number	: 10360		
P.O. Number	: N/A	Part Number	: D2350
This Issue	: 4/4/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2350 / D2363
First Issue	: N/A	Project Number	: N/A
Previous Run	: 26442	Drawing Revision	: B / E
	Type : MACHINED PARTS	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 4/24/2006
Checked & Approved By	: <u>06.04.04</u>	Qty:	4 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

D6201

T Extrusion 4X4X3/8



Comment: Qty.: 1.0631 f(s)/Unit Total: 4.2525 f(s)

Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion

Batch: A 26538

2.0

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks: 12.150" long

SA 06.05.06

4

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio D2363 and Dwg D2363

SA 06.05.06

4

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 06.05.06

4

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J-G 06105108

4

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Tumble & deburr

SA 06.05.06

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:26:43 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 26488

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

H.M 06/05/09

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

G.M 06-05-16

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2372 Fastener

B19507

12.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2444 Pip Pin

B25824

13.0

AN960JD10L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

3 AN960JD10L Washer

M18235

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:26:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 26488

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3

Nut (or -3)

M18917

15.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-13

Screw

M13719

JAP 05:05:17

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST171

16/1/19 (4)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/23

Job Completion



U 06-05-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-17	15.1	Assy as per Dwg. Add to Estimate - permanent change	SAD	06-05-17	4		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06-05-17
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-17	4 15.1	1x D2372 was damaged by the drill chuck, when removing the puncher out of the pip pin holes.		Scrap & replace 1x D2372.	SAD 06-05-18			

NOTE: Date & initial all entries

DART

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED <i>[Signature]</i>	DRAWING NO. D2350	REV. B SHEET 1 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY SCALE	

RELEASED
960607

D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
<i>X</i> 3	AD960JD10 L	WASHER
1	MS21042L3	NUT
1	MS27039-A-13	SCREW

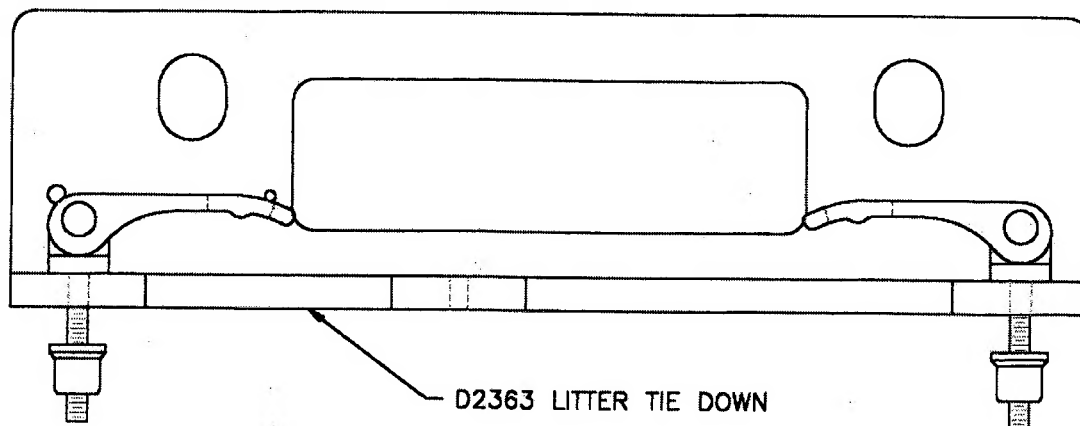
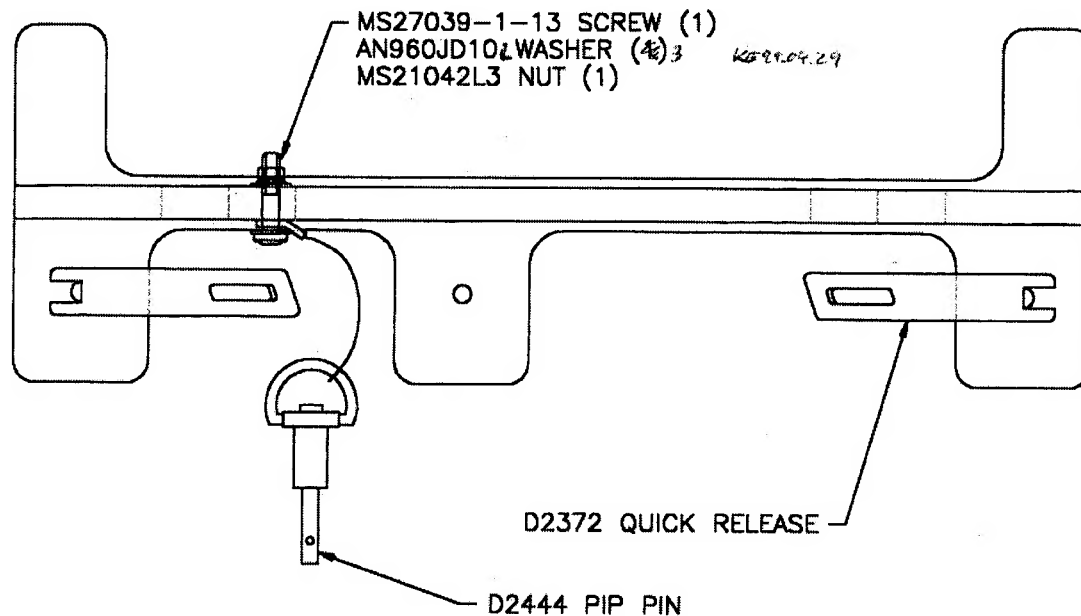
KE 99.04.29

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WITHOUT NOTICE
WORK ORDER
NO. 26488



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED BW	APPROVED	D2350	SHEET 2 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY	SCALE

RELEASED
960607

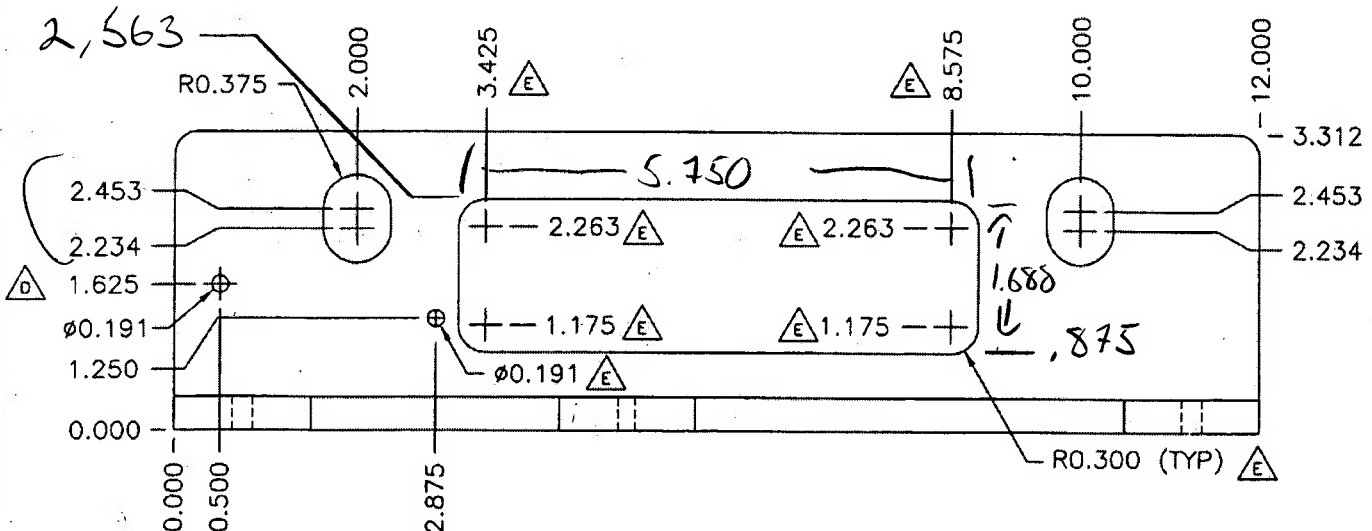
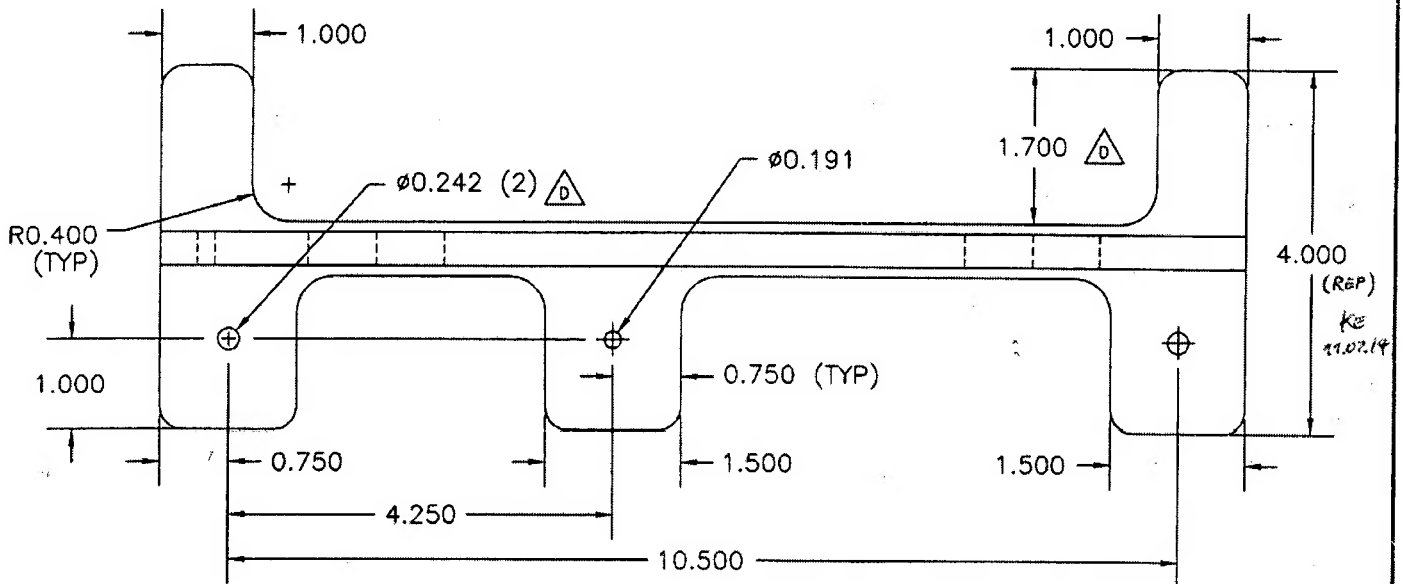


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NO. 26488

DART

DESIGN BW	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BIOY	APPROVED BW	DRAWING NO. D2363	REV. E SHEET 1 OF 1
DATE 97.10.01		TITLE LITTER TIE DOWN BRACKET	SCALE 1:2
A	95.01.14	NEW ISSUE	
B	95.02.14	MODIFIED HOLES	
C	95.03.06	0.191 WAS 0.197	
D	95.03.06	CHANGES TO DIMENSIONS	
E	97.10.01	CHANGES FOR MACHINING	

RELEASED
971003 KE
TSR A129



MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8 'T' SECTION
FINISH: ANODIZE

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WORK ORDER
NO. 26488

10

Part Number:

Page 1 of 1

25.


FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	$\pm .010$	1.002	/			
1.000	$\pm .010$	1.002				
4.000	$\pm .010$					
1.700	$\pm .010$	1.6995	/			
1.500	$\pm .010$	1.501	/			
.750 (H-p)	$\pm .010$.750	/			
10.500	$\pm .010$	10.499	/			
4.250	$\pm .010$	4.250	/			
R.400	$\pm .010$.390	/			
Ø.242	$\pm .005$	Ø.242	/			
Ø.191	"	Ø.191	/			
1.250	$\pm .010$	1.248	/			
1.625	$\pm .010$	1.623	/			
2.000	$\pm .010$	2.002	/			
10.000	$\pm .010$	10.002	/			
12.000	$\pm .010$	12.001	/			
3.312	$\pm .010$	3.312	/			
R.300	$\pm .010$.290	/			
Ø.191	$\pm .005$.191	/			
2.875	$\pm .010$	2.872	/			
.500	$\pm .010$.498	/			

Measured by	SD
	06.05.06

Audited by:  Date: 06.05.06

Prototype Approval:	Date:
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Revised by	Approved
KURE	